












Date: Monday, 6/26/2006 11:54:45 AM
User: Jean-Luc Menard

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services		Drawing Name : MOUNTING BRACKET	
Job Number : 27670			
Estimate Number : 12473			
P.O. Number : <u>N/A</u>	S.O. No. : <u>N/A</u>	Part Number : D3246041	
This Issue : 6/26/2006		Drawing Number : D3246 REV A1	
Prsht Rev. : NC		Project Number : N/A	
First Issue : 6/23/2006	Type : SMALL /MED FAB	Drawing Revision : A1	
Previous Run : <u>N/A</u>		Material : <u>N/A</u>	
Written By : _____		Due Date : 6/29/2006	Qty: 4 Um: Each
Checked & Approved By : _____			
Comment : Est Rev:A New Issue 06-06-22 JLM			
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	M2024T3S050	2024-T3 .050 sheet	
			
<p>Comment: Qty.: 0.3252 sf(s)/Unit Total : 1.3007 sf(s)</p> <p>2024-T3 .050 sheet</p> <p>Material: 2024-T3 (QQ-A-250/4) 0.050" thick</p> <p>(M2024T3S.050)</p> <p>Identify for D3246-1 Batch: <u>B19053</u></p>			
2.0	WATER JET	FLOW WATER JET	
			
<p>Comment: FLOW WATER JET</p> <p>1-Cut as per Dwg Dsi9279</p> <p>Dwg Rev: <u>A1</u></p> <p>Prog Rev: <u>A1</u></p> <p>2-Deburr if necessary</p> <p><u>SAN 06:06:289</u></p>			
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
			
<p>Comment: INSPECT PARTS AS THEY COME OFF MACHINE</p> <p><u>SAN 06:06:289</u></p>			
4.0	QC8	SECOND CHECK	
			
<p>Comment: SECOND CHECK</p> <p><u>San 06:06:304</u></p>			
5.0	BRAKE NC	NC BRAKE	
			
<p>Comment: NC BRAKE</p> <p>Deburr</p> <p>Form as per Dwg D3246</p> <p><u>SB 06/07/124</u></p>			

Date: Thursday, 20/07/2006 11:04:10 AM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: MOUNTING BRACKET
Job Number	: 27670		
Estimate Number	: 12473		
P.O. Number	:	Part Number	: D3246041
This Issue	: 20/07/2006 S.O. No. :	Drawing Number	: D3246 REV A1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 23/06/2006 Type : SMALL /MED FAB	Drawing Revision	: A1
Previous Run	:	Material	:
Written By	:	Due Date	: 29/06/2006 Qty: 4 Um: Each
Checked & Approved By	:		
Comment	: Est Rev:A New Issue 06-06-22 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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10.0	MS21059L3	Nut Plate
------	-----------	-----------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Nut Plate

Pick:

Qty	Part Number	Description	Batch
4	MS21059L3	Nut Plate	

Identify as D3246-041

11.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
------	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1
ASSEMBLE PER DRGW D3246 REV.A

SAD 06:07:20

(3)

12.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

13.0	DC	DOCUMENT CONTROL
------	----	------------------



Comment: DOCUMENT CONTROL
Inspection Level 21

Job Completion



See next page

Date: Monday, 6/26/2006 11:54:45 AM
User: Jean-Luc Menard

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING BRACKET

Job Number: 27670

Part Number: D3246041

Job Number:



Seq. #:

Machine Or Operation:

Description :

C'sink as per Dwg D3246

SAN

06:07:17

(4)

6.0

QC5

INSPECT WORK TO CURRENT STEP



06-07-18

(3)

Comment: INSPECT WORK TO CURRENT STEP

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FF 06-07-20

3

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SAN

06:07:20

(3)

9.0

MS20426AD33

Rivet



Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)

Rivet

Pick:

Qty Part Number Description Batch

8 MS20426AD33 Rivet

M7681

10.0

MS21059L3

Nut Plate



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Nut Plate

Pick:

Qty Part Number Description Batch

4 MS21059L3 Nut Plate

M19393

Identify as D3246-041

SAN 06:07:20

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

12.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/09/11

(3)

10/ stock

06/09/11 (3)

06/09/11

Date: 6/23/2006 7:39AM
User: Kim Johnston

PROCESS SHEET

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: MOUNTING BRACKET
Job No.	: 27670	Part No.	: D3246041
Estimate No.	: 12473	Drawing No.	: D3246 REV A1
P.O. No.	: <u> </u> SO No. <u> </u>	Drawing Rev.	: A1
First Issue	: / /	Project No.	: N/A
Prsht Rev.	: NC Type : SMALL /MED FAB	Material	: <u> </u>
This Issue	: 6/23/2006	Due Date	: 6/29/2006 QTY: 4
Prev. Run	: <u> </u>		


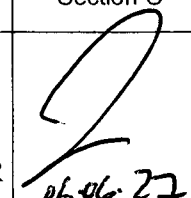
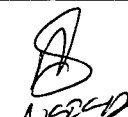
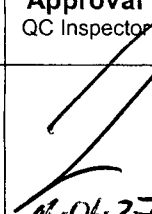
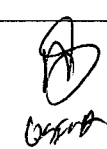
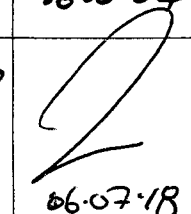
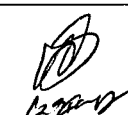
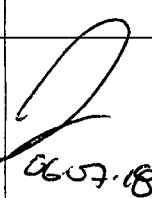
Written by:
Checked & Approved by:
Comment : Est Rev:A New Issue 06-06-22 JLM

Job Number:



Seq. No.	Machine or Operation	Description
1.0	M2024T3S050	2024-T3 .050 sheet
	Comment: Qty.: 0.3252 sf(s)/Unit Total : 1.3007 sf(s) 2024-T3 .050 sheet Material: 2024-T3 (QQ-A-250/4) 0.050" thick (M2024T3S.050) Identify for D3246-1 Batch: <u> </u>	
2.0	WATER JET	FLOW WATER JET
	Comment: FLOW WATER JET 1-Cut as per Dwg Dsi9279 Dwg Rev: <u> </u> Prog Rev: <u> </u> 2-Deburr if necessary	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK
	Comment: SECOND CHECK	
5.0	BRAKE NC	NC BRAKE
	Comment: NC BRAKE Deburr Form as per Dwg D3246 C'sink as per Dwg D3246	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR: 27670		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06-06-27	20	8 parts scrapped. 4x the grain was in the wrong direction. 4x the pierce point of the water jet was on the inside of the part.	 06-06-27	Scrap: destroy parts at Y8. Replace, after achieving good grain direction. The pierce is on the outside of the part.	SAN 06-06-27	 06-06-27	 06-06-27	 06-06-27
06-07-18	5-0	1 part scrap. (sink was too deep)	 06-07-18	DESTROY.	SAN 06-07-18	 06-07-18	 06-07-18	 06-07-18















Part No: D3246-041PAR #: N/AFault Category: Prod / ^{FAB' POS' MED} SMALLNCR: Yes NoDQA: Date: 06/09/11

NOTE: Date & initial all entries

QA: N/C Closed: Date: 06.09.11

Job Number:



Seq. No.	Machine or Operation	Description
6.0	QC5	INSPECT WORK TO CURRENT STEP
		
	Comment: INSPECT WORK TO CURRENT STEP	
7.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
		
	Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1	
8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
		
	Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION	
9.0	MS20426AD33	Rivet
		
	Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s) Rivet Pick: Qty Part Number DescriptionBatch 8 MS20426AD3-3 Rivet	
10.0	MS21059L3	Nut Plate
		
	Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s) Nut Plate Pick: Qty Part Number Description Batch 4 MS21059L3 Nut Plate _____ Identify as D3246-041	
11.0	QC5	INSPECT WORK TO CURRENT STEP
		
	Comment: INSPECT WORK TO CURRENT STEP	
12.0	DC	DOCUMENT CONTROL
		
	Comment: DOCUMENT CONTROL Inspection Level 21	

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

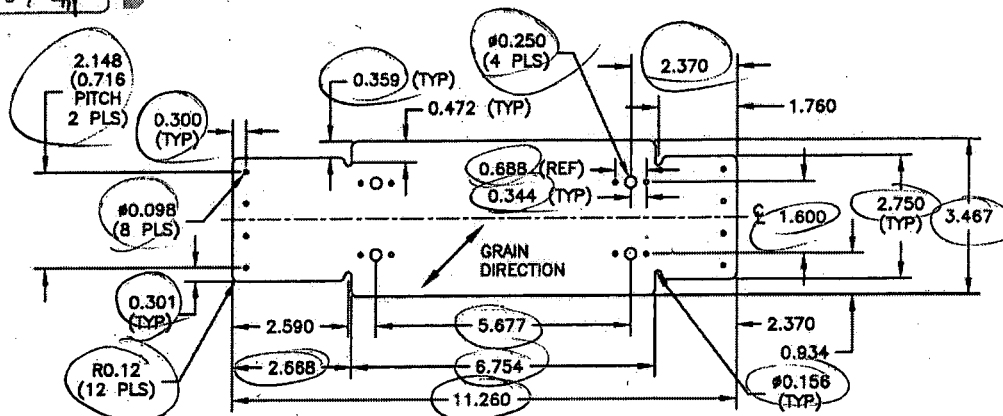
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

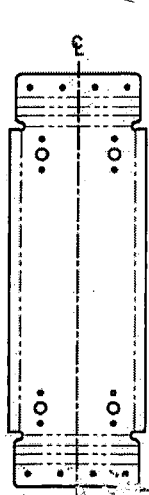


DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3246	REV. A SHEET 1 OF 1
DATE 04.04.21	TITLE MOUNTING BRACKET		SCALE 1:4
A	04.04.21	NEW ISSUE	
AI	04.06.16	CHANGE RIVET; ADDED C SINK	

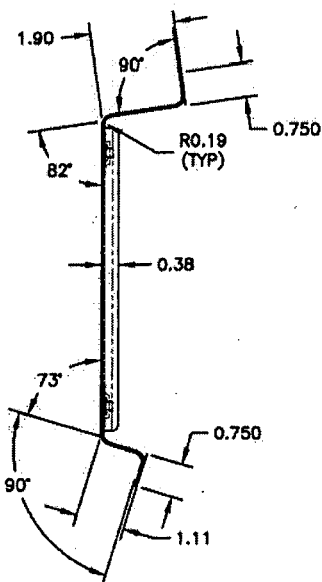
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04.05.07



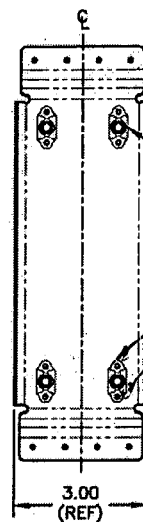
D3246-1 FLAT PATTERN



D3246-1 BEND DETAIL



D3246-041 ASSEMBLY



MS21059-L3
NUT PLATE (1)
MS20470AD3-4-RIVET (2)
(4 PLACES)
INSTALL AFTER
ALODINE
C SINK $\phi 0.185 \times 100^\circ$
MS20426AD3-3-RIVET (2)
(TYP)

06.07.20



NOTES:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.050 THICK (REF. DART SPEC. M2024T3S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

SHOP COPY
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WITHOUT NOTICE
WORK ORDER
NO. 22670

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DART AEROSPACE LTD		Work Order: 27670
Description:		Part Number: D 324664/
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.148	± 0.010	2.148 2.146	✓		vern	
0.300	± 0.010	0.298	✓			
0.098	$\pm 0.004 / -0.001$	0.100	✓			
0.301	± 0.010	0.300	✓			
2.668	± 0.010	2.669	✓		↓	
5.677	± 0.010	5.680	✓		vern	
6.754	± 0.010	6.747	✓		Tape: vern	
11.260	± 0.010	11.269	✓		Tape: vern	
0.156	$\pm 0.005 / -0.001$	0.150	✓		vern	
1.600	± 0.010	1.607	✓			
2.750	± 0.010	2.749	✓			
3.467	± 0.010	3.463	✓			
2.370	± 0.010	2.377	✓			
0.250	$\pm 0.005 / -0.001$	0.252	✓			
0.359	± 0.010	0.366	✓			
0.688	± 0.010	0.684	✓		↓	
0.344	± 0.010	0.346	✓		vern	

Measured by: SAD	Audited by:	Prototype Approval:
Date: 05.06.29	Date: 06.06.30	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	